



Dart Aerospace Ltd.
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D3168-041
Job Sheet 182909



Part No: D3168-041

Job Qty: 1 ea

Part Name: Step Assembly, Low Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/6/18

Job Tracking No:

Due Date: 9/28/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Large Fab-7		CPC
110	Large Fab	1 pcs	9/28/18	9/28/18	0.00	0.10	Large Fab 8		CPC DAS
120	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		OCT 01 2018 68
130	Large Fab	1 pcs	9/28/18	9/28/18	0.00	0.20	Large Fab 2		CPC 9-89
140	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC10-9		CPC
150	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		CPC
160	HandFinish	1 pcs	9/28/18	9/28/18	0.00	0.10	HandFinish1		D.R. 18/10/2
170	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC7-5		CPC
180	Large Fab	1 pcs	9/28/18	9/28/18	0.00	0.10	Large Fab 8		CPC
190	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5		CPC
200	HandFinish	1 pcs	9/28/18	9/28/18	0.00	0.10	HandFinish6		D.R. 18/10/2
210	Powdercoat	1 pcs	9/28/18	9/28/18	0.00	0.10	Powdercoat1		13/2 18-10-3
220	HandFinish	1 pcs	9/28/18	9/28/18	0.00	0.10	HandFinish3		BEB 18-10-03
230	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC3		38
290	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-2		38
300	QC21-FG	1 Ea	9/28/18	9/28/18	0.00	0.00	QC21		OCT 04 2018

Part Op 110 - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168. 2-Drill extrusion as per Dwg D3168 using Jig Descriptions: DT8680 for rivets.(Use only 1st 6holes). 3-Deburr.

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, as per QSI 004 & Dwg D3168 A/R Aluminum Rod 3- Grind end plate flush as per DWG.

180 - Rivet Leg Assembly as per Dwg D3168 1-Bevel end for welding 2-Inspect for foreign object as per QSI 024 3-Weld end plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod 4- Grind end plate flush as per dwg

210 - START TIME: 9:30 OVEN TEMPERATURE: 320° FINISH TIME: 10:00

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Container No: S115052



Part: D3168-041

Job No: 182909

Serial No/Batch: S115052

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/01/18

wing walk. 5098120

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 Ea (.5 ea)	90-Start up Operation	S104007
D3067-1	End Plate	1 Ea (1 ea)	90-Start up Operation	S104284
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	S104284
D3077-1	Step Leg	2 Ea (2 ea)	180-Large Fab	S081376
D3170-1	Spacer	2 Ea (2 ea)	180-Large Fab	R116 F164390
D3219-5	Plate	2 Ea (2 ea)	180-Large Fab	F146687
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab	S016803

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	183	0
	D3067-1	1	166	0
180-Large Fab	D3067-1	1	166	0
	D3077-1	2	8	0
	D3170-1	2	7	0
	D3219-5	2	37	0
	MS20600-AD4W4	12	1,202	0

Part Specifications

Specifications could not be found.

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